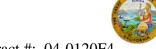
### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

# WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-011844 Address: 333 Burma Road **Date Inspected:** 07-Feb-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes Li Yang and Wu Zhi Cheng No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No **Delayed / Cancelled:** Yes No N/A

34-0006 **Bridge No: Component: OBG** Trial Assembly

## **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 6CW to 7AW

This QA Inspector observed ZPMC welding personnel performing repair welding from inside by Flux Cored Arc Welding (FCAW) for Linear Misalignment which was found at Side Panel to Bottom Panel after Inspection. The weld joints are identified as Seg033B-001, Seg033B-009 and Seg033B-011. The welder is identified as 220066. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-3G (3F)-Repair. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 6CW to 7AW

This QA Inspector observed ZPMC welding personnel performing repair welding from External side by Shielded Metal Arc Welding (SMAW) for Linear Misalignment which was found at Side Panel to Bottom Panel after Inspection. The weld joints are identified as Seg033A-004. The welder is identified as 037932. In process SMAW

# WELDING INSPECTION REPORT

(Continued Page 2 of 3)

appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G (4F)-FCM-Repair-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Corner Assembly Counter Weight side for Transverse Splice Weld. The weld joints are identified as OBW7C -006. The welder is identified as 068917. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Corner Assembly Cross Beam Side for Transverse Splice Weld. The weld joints are identified as OBW7C -010. The welder is identified as 069683. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Counter Weight side for Transverse Splice Weld. The weld joints are identified as OBW7C -007. The welder is identified as 068917. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Cross Beam Side for Transverse Splice Weld. The weld joints are identified as OBW7C -009. The welder is identified as 069683. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Bottom Panel for Transverse Splice Weld. The weld joints are identified as OBW7C -008. The welder is identified as 069683. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

# WELDING INSPECTION REPORT

(Continued Page 3 of 3)

7BW to 7CW

This QA Inspector observed ZPMC personnel's at Segment 7BW to 7CW between Panel Point (PP) 52 and PP 53 Bottom Panel, Side Panel (Cross Beam and Counter Weight side) welding is in progress for Transverse Splice.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel's Segment 6CW to 7AW between PP 47 and PP 48 Side Panel to Bottom misaligned area against B-WR 10059 welding is in progress.

6CW

This QA Inspector observed ZPMC personnel's counter weight side Suspender Bracket installation is in progress.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### **Summary of Conversations:**

No relevant conversations.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

<b>Inspected By:</b>	Math, Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer